

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018555**Date Inspected:** 11-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 1G-005 of SBK023-106 for SB106E. The welder is identified as 062732. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 1G-005 of SBK023-104 for SB104E. The welder is identified as 062783. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 1G-005 of SBK022-106 for SB106W. The welder is identified as 062762. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 1G-005 of SBK022-104 for SB104W. The welder is identified as 062762. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

SMAW welding of critical repair weld is identified as 4F-153 of BK004B6-001for BK004B-001. The welder is

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identified as 062814. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-4F-Repair and B-CWR2430.

ZPMC personnel performing Heat straightening of bike path bottom covering plate is in progress. The bike path is identified as BK004A-006. The measured distortion by using 600mm straight edge across the weld is 8mm max.

The weld is identified as BK004A2-016,018.

Is appeared to comply with HSR1 (B)-9501 dated on 10.01.2010.

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A3-001-005,009.

BK004A5-001-007,004.

BK4ASD1-013-005,006,018,021.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer